

Work Order ID 65464

January 18, 2011 10:30:09 AM



Page 1

Item ID: D206-746-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Blower Motor Assembly

Start Date: 1/18/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 1/10/18

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9341	Rev C

100 0.00



DOCUMENT CONTROL

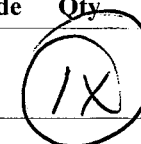
DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-746-043 CHG 001



Handwritten signature

110 A



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Change bearing - D3742-1 B Batch: B48562

Assemble as per dwg DSI 9341

Center punch set-screw, then drill as per dwg.

Add locktite 26221 to fan set screw batch: M13436

Secure using Lock Wire

A/R MS20995-025E LOCK WIRE Batch: M18670

Handwritten: M-L 11/02/02

Handwritten: Pick kit

Handwritten: Per 1/25 (1)

Handwritten: 110 B

Handwritten: Test

*Handwritten: Run motor for 12 hours at 1/2 speed
Ensure amperage draw is not more than 8.7 amp at 27.5 volts*

Handwritten: 11/02/02 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65464

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Page 2

Item ID: D206-746-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Blower Motor Assembly

Start Date: 1/18/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Dulor



Quality Control

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-746-043

Location:

PPP Rev:

PP 65421



140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Puff/3 C

11/02/04

mf

11-02-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

January 18, 2011 10:30:09 AM

Parent Item: D206-746-043





Parent Item Name: Blower Motor Assembly

Start Date: 1/18/11**Required Date:** 1/31/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 06.08.21 New Issue EC
IPP rev B 07.03.15 DSI 9341 Rev B KJ
IPP Rev:C 08-02-12 change to rev.c DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
26D71  Blower Motor		Purchased	No			110	Each	0.0000	1	1		11/02/01	
AN3-3A  Bolt		Purchased	No			110	Each	265.0000	6	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		265							
				116400		65							
				116419		150							
				116590		50							
AN960-10  Washer	NAS1149F0363P	Purchased	No			110	Each	7,877.000	6	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST348		7877							
				19356		200							
				5519		7677							
D3471-041  Blower Motor Support		Manufactured	No			110	Each	1.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST159		1							
				48304		1							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 65464

Parent Item: D206-746-043

Parent Item Name: Blower Motor Assembly

Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 1.00

Required Qty: 1.00

D3473-041

Manufactured No

110 Each

2.0000

1

1



Blower Inlet Adapter



Location

Loc Qty

Loc Code

ST160

2

37114

2

D3476-041

Manufactured No

110 Each

3.0000

1



Blower Motor Adapter



Location

Loc Qty

Loc Code

ST156

3

45185

3

D3477-041

Manufactured No

110 Each

0.0000

1



Blower Motor Inlet Adapter



D3585-1

Manufactured No

110 Each

101.0000

2

2



Set Screw



Location

Loc Qty

Loc Code

ST072

101

31571

1

55705

100

D3742-1

Manufactured No

110 Each

4.0000

2

2



Bearing



Location

Loc Qty

Loc Code

ST086

4

48562

4

98862

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 3

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Work Order ID: 65464

Parent Item: D206-746-043

Parent Item Name: Blower Motor Assembly

Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-04

Purchased

No

110

Each

263.0000

3

3



SCREW



Location

Loc Qty

Loc Code

ST290

263

109752

263

120

Each

87.0000

3

3

MS35333-38

Purchased

No



LOCK WASHER



Location

Loc Qty

Loc Code

ST295

87

107063

87

109752

3

107063

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Page 3

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-746 REV. A
REF. CANADIAN STC: SH05-45 ISSUE 1
FAA STC: SH3367NM DATED OCT. 13, 2005

The Parts List of Installation Instructions IIN-D206-746 Rev. A should be amended as follows:

Qty -011	Qty -041	Qty -043	Part Number	Description
X			D206-746-011	SHROUD AIRFLOW HEATER SYSTEM
1	X		D206-746-041	REAR OVERHEAD PASSENGER MODIFICATION KIT
1		X	D206-746-043	BLOWER MOTOR ASSEMBLY
		1	D3471-041	BLOWER MOTOR SUPPORT (CAM-1984-008)
		1	D3473-041	BLOWER INLET ADAPTER (CAM-1984-013)
		1	D3476-041	BLOWER MOTOR ADAPTER (CAM-1984-014)
		1	D3477-041	BLOWER MOTOR INLET ADAPTER (CAM-1984-015)
		2	D3585-1	SET SCREW
		2	D3742-1	BEARING
		A/R	26221	LOCTITE 226 THREADLOCKER
		1	26D71	BLOWER MOTOR (26D71-1)
		6	AN3-3A	BOLT
		6	AN960-10	WASHER
		3	MS27039-08-04	MACHINE SCREW
		3	MS35333-38	LOCK WASHER
		A/R	MS20995-025E	LOCK WIRE

Furthermore, any mention of "Blower Motor Assembly" appearing in Installation Instructions IIN-D206-746 Rev. A, and Installation Drawing D206-746 Rev. A, should be replaced by D206-746-043 Blower Motor Assembly.

For assembly instructions of D206-746-043 Blower Motor Assembly, refer to page 2 of this DSI.

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WITHOUT NOTICE
WORK ORDER
NO. 625464
C&I 11/01/18

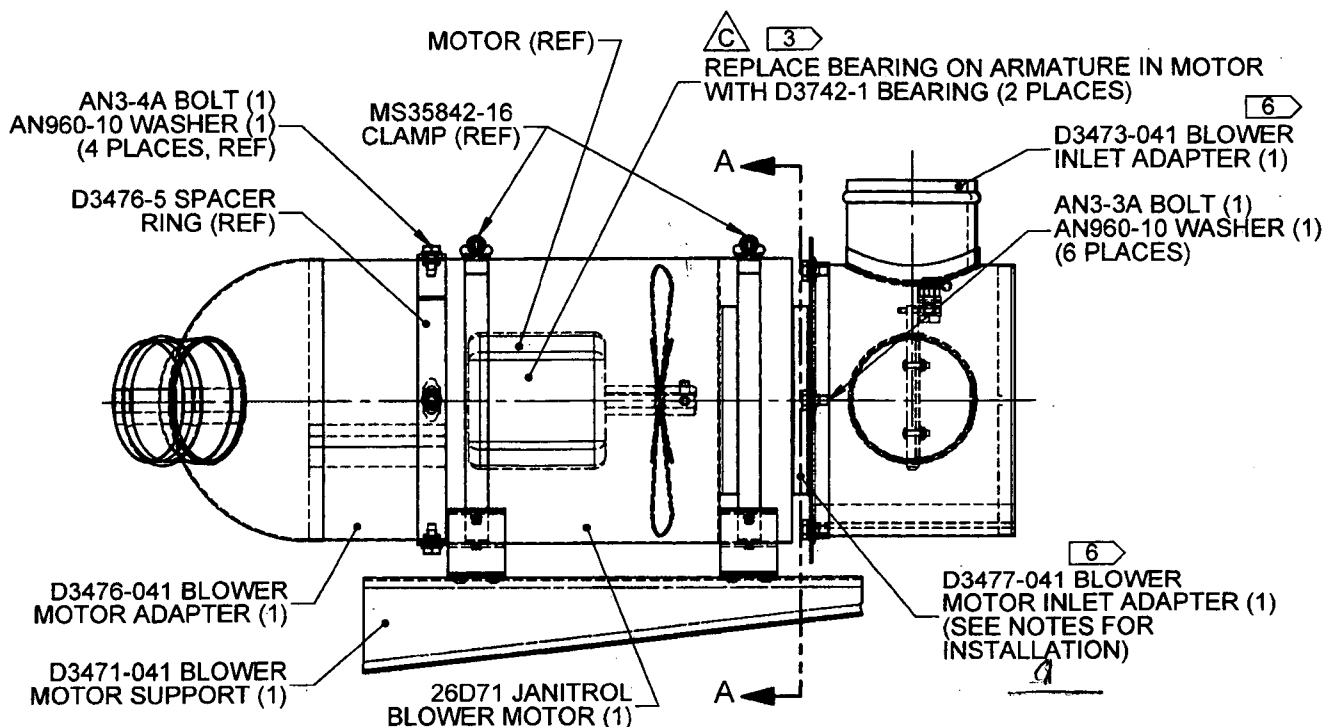
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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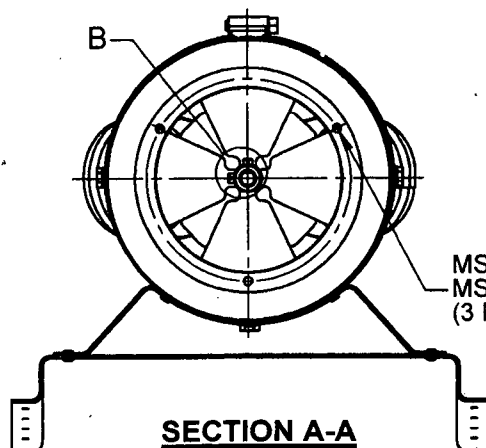
BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 08.01.20
CERT. NO.: SH05-45
ISSUE NO.: 1

C	ADD D3742-1.BEARING; UPDATE FORMAT	PH	08.01.20
B	ADD D3585-1 & DETAIL B	MB	07.01.02
A	NEW ISSUE	MB	06.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		DSI 9341	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BLOWER MOTOR ASSEMBLY	NTS
DATE	08.01.20	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



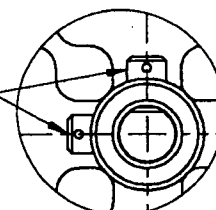
D206-746-043 BLOWER MOTOR ASSEMBLY



SECTION A-A

4
REPLACE EXISTING SET SCREWS
WITH D3585-1 SET SCREWS (2),
APPLY LOCTITE 226, TORQUE TO
50-70 in-lbs (5.6-7.9 N-m) AND SECURE
USING MS20995-025E LOCK WIRE

1
MS27039-08-04 MACHINE SCREW (1)
MS35333-38 LOCK WASHER (1) RETURN TO
(3 PLACES) ENGINEERING



**DETAIL B
SCALE 1:1**

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WITHOUT NOTICE
WORK ORDER
NO. 65462

INSTALLATION NOTES:

- 1) ON 26D71 BLOWER MOTOR, REMOVE EXISTING MACHINE SCREWS (3), LOCK WASHERS (3) AND EXISTING ADAPTER (1).
- 2) REMOVE MOTOR AND RETAIN HARDWARE
- 3) REPLACE BEARINGS WITH D3742-1 BEARINGS (2 PLACES)
- 4) REPLACE SET SCREWS WITH D3585-1 SET SCREWS (2 PLACES)
- 5) RE-INSTALL MOTOR WITH HARDWARE REMOVED AT STEP 2
- 6) REPLACE ADAPTER WITH D3477-041 BLOWER INLET ADAPTER. USE HARDWARE REMOVED AT STEP 1 TO SECURE D3473-041/D3477-041 BLOWER INLET ADAPTER TO 26D71 JANITROL BLOWER MOTOR.
- 7) D206-746-043 IS SUPPLIED TO CUSTOMER PRE-ASSEMBLED

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

DATE: 08.01.20
CERT. NO.: SH05-45
ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	<i>EE</i>	DSI 9341	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BLOWER MOTOR ASSEMBLY	1:4
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